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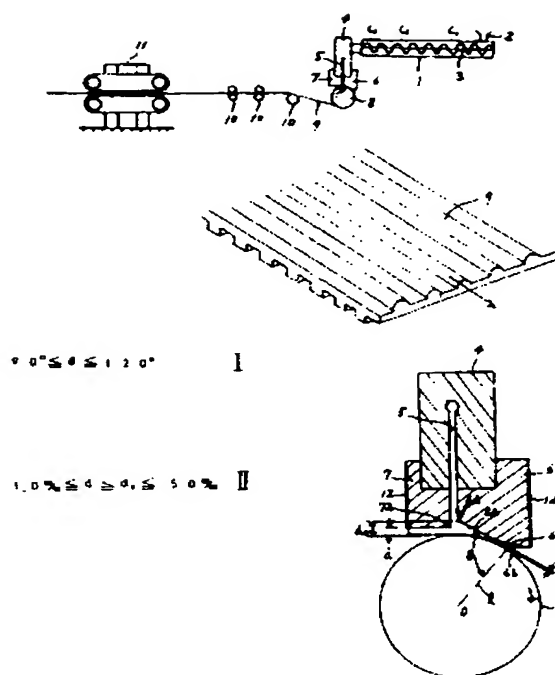
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APPLICANT : UBE IND LTD;

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TITLE : FORMING DEVICE FOR
THERMOPLASTIC RESIN SHEET WITH
PATTERNED SURFACES AT BOTH
SIDES



ABSTRACT : PURPOSE: To avoid the influence of variation in extrusion pressure and to obtain a uniform sheet, by a method wherein a resin molding material is extruded onto a rotating patterned roll through a gap between a wedge-shaped die having a pattern-forming groove at a lower end thereof and a rear die to form a sheet.

CONSTITUTION: A resin molding material flowing through a hopper 2, a screw 3, and a resin passage 5 of a die 4 is extruded onto a patterned roll 8 through a gap between a wedge-shaped die 6 and a rear die 7, and the material passing along a circumference surface is solidified to form a sheet. A large number of grooves, made at a lower end of the wedge-shaped die 6 and in parallelism with the extrusion direction, form an embossed pattern on an upper surface of the molded sheet, and a pattern on the circumference of the patterned roll 8 is transferred on a back surface of the molded sheet to form the sheet with patterned surfaces at both sides. There can be satisfied the conditions of an inequality I and an inequality II, where θ is an angle formed by a straight line I, which links a lower end of the wedge-shaped die 6 to a center O of the patterned roll 8, and a slope 6a, d_0 is a distance between the upper end of the roll 8 and the upper surface of the roll 8, and d is a distance between a rear die 7a and the upper surface of the roll 8.

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